

23

Date: Wednesday, 5/16/2007 8:13:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 32376B
 Estimate Number : 10339
 P.O. Number : N/A Part Number : D2658
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2658 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D
 Previous Run : 32018B Material : N/A
 Due Date : 6/6/2007 Qty: 32 Um: Each
 Written By :
 Checked & Approved By : 07.05.16
 Comment : Est Rev:A New Issue 05-11-07 JLM
 Est Rev:B Now on Waterjet 06-08-23 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S12GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.1197 sf(s)/Unit Total : 3.8304 sf(s)

1010/1025/A21/6aA SHEET

12 GAUGE .100" THK

Batch: M104 288

SAD

07/06/12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2858

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

SAD 07/06/12 (32)

SAD

07/06/12

32

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/06/12

32

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/06/12 (32)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr as required.

SAD 07/06/12 (32)

2-Bend on CNC brake using DT8254 Identify as D2658

SAD 07/06/12

(32)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 32376B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 07/06/21

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A*

FC 07/06/21 (32)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(32)
FC 07/06/25

Job Completion



U 07-06-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

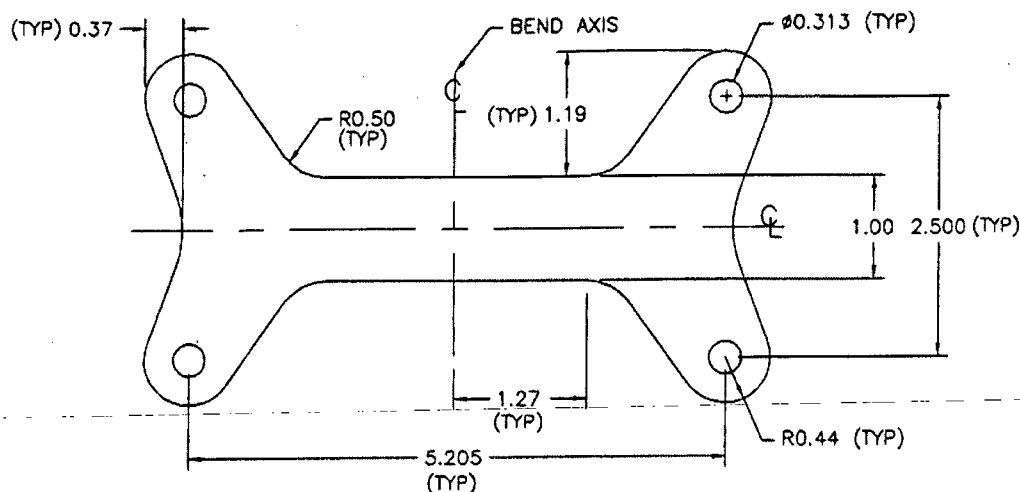
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

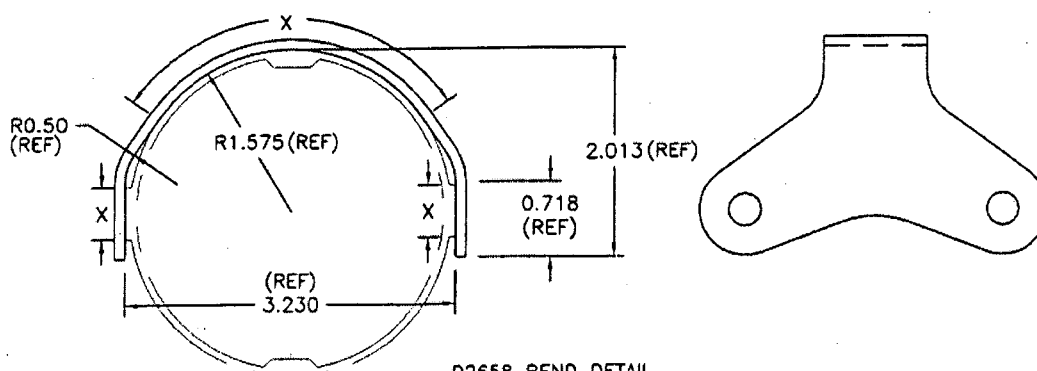


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. 'D' SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32376B